

Date: Wednesday, 6/6/2007 1:41:57 PM
 User: Kim Johnston

Process Sheet

24

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DART 13-MAN 3-POINT SHOULDER HARNESS KIT		
Job Number	: 32759		Part Number	: D412702041B		
Estimate Number	: 12865		Drawing Number	: D412702041B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/6/2007 S.O. No. : N/A		Drawing Revision	: D		
Prshtr Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 6/15/2007 Qty: 2 Um: Each		
Previous Run	: 32419					
Written By	:					
Checked & Approved By	:					
Comment	: est rev A 07.05.10 new issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL   (2)
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-702-041B CHG001 002 KJ 07.06.08		
2.0	D412702059	GROMMET KIT   (2)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) GROMMET KIT batch: B32327-1		
3.0	D412702101B	HARNESS ASSEMBLY   (2)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32790		
4.0	D412702103B	HARNESS ASSEMBLY   (2)
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32809		
5.0	D412702105B	HARNESS ASSEMBLY   (2)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) HARNESS ASSEMBLY batch: B32608-1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D412702107B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32791

7.0 D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32488

8.0 D412702111B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32489

9.0 D412702113B

HARNESS ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: B32490

10.0 D412702115B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32491

11.0 D412702117B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: B32340

12.0 D35421

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET

batch: B32606

6/6/07/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	D35711	GUIDE
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s) GUIDE batch: B31868 ✓	
14.0	D35713	GUIDE
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) GUIDE batch: B31869 ✓	
15.0	D3572041	GUIDE ASSEMBLY
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) GUIDE ASSEMBLY batch: B31870 ✓	
16.0	D3578041	DOUBLER
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s) DOUBLER batch: B32483 (9x) B31876 (4x) B32831 3x	
17.0	D3610041	BRACKET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) BRACKET batch: B32607 2x ✓ B32240 (2x) ✓	
18.0	D36181	CAP
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) CAP batch: B32426 ✓	
19.0	AN410A	Bolt
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Bolt batch: M101291 ✓	

06/06/04 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN416A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M18949 ✓

21.0 AN425A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: M104438 ✓

22.0 AN44A Eyebolt

AN4-44A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eyebolt

batch: M104491 ✓

SUBSTITUTE AN4-44A BOLT
PER IIN-D412-702

LE 07.06.20

M104491

23.0 MS24693S274 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104214 ✓

24.0 MS24694S56 SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

SCREW

batch: M104407 ✓

25.0 MS24694S58 Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

batch: M11735 ✓

26.0 MS24694S60 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M104407 ✓

EJ 07/06/14 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:41:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32759

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

27.0 AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer

batch: M103691-1

28.0 AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M103962

29.0 MS2104L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

batch: M102552

30.0 CR321244

Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Cherry Rivet

batch: M16896

31.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



32.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG001

Location: 10

PPP Rev: 10

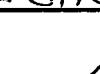


33.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1*	1*			1*	D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL

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Revision: D
Date: 07.04.12

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1		1			D412-702-115B	HARNESS ASSEMBLY
1*		1*			D3573-5	ADAPTER
1*		1*			D3579-046	SHOULDER HARNESS
1*		1*			K6.2	CLIP
4*		4*			MS24693S272	SCREW
4*		4*			AN960JD10LL	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1		1			D412-702-117B	HARNESS ASSEMBLY
1*		1*			D3573-5	ADAPTER
1*		1*			D3579-045	SHOULDER HARNESS
1*		1*			K6.2	CLIP
4*		4*			MS24693S272	SCREW
4*		4*			AN960JD10LL	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D
Date: 07.04.12

Date: Thursday, 15/11/2007 6:55:16 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D412-702-UPDATE PAPERWORK		
Job Number	: 35746		Part Number	: Z_CUSTOM		
Estimate Number	: 10804		Drawing Number	: ECN 1065		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 15/11/2007	S.O. No.	: N/A	Drawing Revision	: N/A	
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 22/11/2007		
Previous Run	: 00015		Qty:	1	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

D412-702-021 31266 2X 30645 2X

D412-702-023 35411 3X

D412-702-025 32001 3X - 31174 3X

D412-702-031 33277 1X

D412-702-033 31453 1X

D412-702-041A 34427 1X - 32759 1X
D412-702-041BD412-702-043A 34212 1X
D412-702-043B 32756 1XD412-702-045A 34213 1X
D412-702-045B 32757 1XD412-702-059 32327-5X
D412-702-069 34435 7XADD NEW PAPERWORK TO KITS IN STOCK
EASA STC EASA.1M.R.S.00710 REV.1

RETURN KITS TO STOCK

CUSTOMER RETURN

Initiator: Dale Tremier
 Company: Windwind Maintenance Inc.

Phone No. _____

Date: June 26/08
 Invoice #: 6518
 Order Entry #: 6043

Attach Copy of DHS Return Authorization # _____

Reason for return: NCR 08-059Buckles are not releasing when belt is pressed.Receiving: 8/2/08Date Received: 8/2/08 Freight Company: FREDCO

#	Part #	Batch #	Description	Prepaid	Collect
				Distribute to QC	Date:
1	D412-702-041A (Harnesses only)	B39085	13-Man Shoulder Harness	Advise QA	8/7/08
2	D412-702-041B (Kit only)	B32759	only the kit was returned from the customers replacement shipment.		
			REFERENCE ONLY		

Condition of packaging: Good Photograph required: yes noPaperwork attached: P/S _____ Invoice _____ ARC _____ Docs _____ Other Return Adv.

QC:

Quarantine: _____ Location: _____

Condition of Part: harnesses Scarp / kit good.Inspect: Initial: J

#	Part #	Batch #	QC Comments	QC Approval	
				Initial	W/O #
1	D412-702-041A (Harnesses only)	B39085	Return harnesses do supplier. They are scrap.	<u>J</u>	40564
2	D412-702-041B (Kit only)	B32759	only the kit was returned from the customers replacement shipment.	<u>J</u>	40564

QA Coordinator:

Advise GM as to findings: Initial: _____ Date: _____

Comments:

Issue credit: yes no

GM Approval: _____

Date: _____

Invoice Amount: _____
 Less Replacement: _____
 Restock Fee: _____
 Freight: _____
 Net Credit: _____
 DHS Customer

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit